

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017876**Date Inspected:** 27-Sep-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Gong Wai**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG COMPONENT**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

In process Inspection

Bay#14

This QA Inspector observed the following work in progress:

FCAW in the 2G position for the OBG segment 13CE, weld No.VP3007-001-025. The welder is identified as #067520. ZPMC QC is identified as Mr.Lv Li Qing. The welding variables recorded by QC appear to comply with WPS-B-T-2232-Tc-U4B-F.

FCAW in the 2G position for the OBG segment 14E, weld No.VP3016-001-013. The welder is identified as #066763. ZPMC QC is identified as Mr. Lv Li Qing. The welding variables recorded by QC appear to comply with WPS-B-T-2232-Tc-U4B-F.

FCAW in the 2G position for the OBG segment 13AE, UT repair weld No.VP3004-001-006. The welder is identified as #044774. ZPMC QC is identified as Mr. Lv Li Qing. The welding variables recorded by QC appear to comply with WPS-345-FCAW-2G(2F)-FCM-REPAIR-1. The weld repair report is identified as WR15270.

FCAW in the 2G position for the OBG segment 13AE, UT repair weld No.VP3004-001-013. The welder is identified as #044774. ZPMC QC is identified as Mr. Lv Li Qing. The welding variables recorded by QC appear to

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comply with WPS-345-FCAW-2G(2F)-FCM-REPAIR-1. The weld repair report is identified as WR15271.

SAW in the 1G position for the OBG segment 13BW, weld No.SEG3014-004. The welder is identified as #045270. ABF QA is identified as Mrs.Lv Yun . The welding variables recorded by QC appear to comply with WPS-B-T-2221-B-L2c-S-2.

FCAW in the 1G position for the OBG segment 13CW to 13BW splice joint, weld No.OBE13A-001. The welder is identified as #045196. ZPMC QC is identified as Mr.Li Mig Yang .The welding variables recorded by QC appear to comply with WPS-B-T-223(2)1T-2.

Bay#19

This QA Inspector observed the following work in progress:

FCAW in the 3F position for the OBG bike path, weld No. BK004A6-013-115/116. The welder is identified as #062795. ZPMC QC is identified as Mr.Xu Tao. The welding variables recorded by QC appear to comply with WPS-B-T-2133.

FCAW in the 2F position for the OBG bike path, weld No. BK004A7-013-224/228. The welder is identified as #062795. ZPMC QC is identified as Mr.Xu Tao. The welding variables recorded by QC appear to comply with WPS-B-T-2132.

FCAW in the 2G position for the OBG bike path, weld No. BK004B1-001-043. The welder is identified as #062762. ZPMC QC is identified as Mr.Liu Dao Fang. The welding variables recorded by QC appear to comply with WPS-B-T-2232-Tc-U4c-F.

Visual Inspection after Blast at 11CE

This Quality Assurance (QA) Inspector performed random visual inspection of OBG segment 11CE internal side panel, edge panel , bottom panel and floor beam surfaces after grit blasting in PP102 to PP103. Areas that marked for repair were recorded for future repair. Areas requiring additional grinding were marked by QA and repaired by ZPMC personnel.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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## Summary of Conversations:

No relevant conversations

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Bera,Subhasis  
**Reviewed By:** Patterson,Rodney

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Quality Assurance Inspector  
QA Reviewer

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